

13/01

Date: Thursday, 04/01/2007 3:24:11 PM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.		Drawing Name	: D412-664-203	
Job Number	: 30183		Part Number	: D412664203A	
Estimate Number	: 10804		Drawing Number	: NCR 095	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 04/01/2007	S.O. No.	N/A	Drawing Revision	: N/A
Prsh Rev.	: NC		Material	: N/A	
First Issue	: 04/01/2007	Type	: LANDING GEAR	Due Date	: 11/01/2007
Previous Run	: 29270		Qty:	1	Um: Each
Written By	:				
Checked & Approved By	:				
Comment	:				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 REMOVE FROM STOCK D412-664-203 RECORD B/N 29528	
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1 REMOVE SUPPORT D2896-1 FROM CROSSTUBES AND LABEL SUPPORT WITH B/N OF CROSSTUBE IT CAME OFF OF	
3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1 REMOVE CENTRE ABRASION STRIP AND CLEAN OFF ALL ADHESIVE RESIDUE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
07-04-09.	2-0	A tiny knick was found before installing the support. Knick is approximately .005" in the material at the top section of the x-tube. R.C. unknown.	J QSI042	Buff and remove knick, sand smooth. Touch-up area with Alodize. Re-paint area as per QSI 005	MM 070411	J 070412	J QSI042	J 07-04-09

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA:

Date: 07/04/12

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Job Number: 30183

Part Number: D412664203A

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0 SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

RE-PAINT SECTION OF CROSSTUBE
BETWEEN THE TWO CHAFING SHIELDS
AS PER QSI 005, APPLY Armor shield B m103815

*BT
M070411 (1)*

6.0 QC14



Comment: Inspect Spray Paint

Inspect Spray Paint

M070412

7.0 LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

INSTALL SUPPORT D2896-1
USING MAGNOBOND 6398 B M102437
ENSURING B/N MATCHES CROSSTUBE
AS PER DSI 9357
REPLACE CLAMPS
2 X MS21920-30B 102931
ADD RUBBER CUSHION
2 X D2182B (D2182B058) B 28472

BT 07-01-04

8.0 MS2192030



clamp(per MIL-DTL-8783C)

Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
clamp(per MIL-DTL-8783C)

M102931*BT 07-01-05*

9.0 D2182B



Neoprene Cushion-.750 bl

Comment: Qty.: 0.9600 f(s)/Unit Total: 0.9600 f(s)
Neoprene Cushion-.750 bl

B 26472*BT 07-01-05*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: _____

Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

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Seq. #:	Machine Or Operation:	Description :
10.0	QC5	INSPECT WORK TO CURRENT STEP <i>Do 704.12 ①</i>
11.0	QC6	DIMENSIONAL CHECK <i>N/A 2</i>
12.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>See 2 Hr back</i>
13.0	QC21	FINAL INSPECTION/W/O RELEASE <i>X</i>

Job Completion



Date: Thursday, 12/04/2007 1:06:35 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D412-664-203

Job Number: 30183

Part Number: D412664203A

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PICK KIT:

13.0 AN640A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M19714 ✓

14.0 AN641A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) ✓

Bolt

Batch: M101418 ✓

15.0 AN960JD616 Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: M103355 ✓ ✓

16.0 MS2104L6 Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s) ✓

Nut

Batch: M101660 ✓

7/4/2008

17.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

✓ 07-04-12

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Job Number: 30183

Part Number: D412664203A

Job Number:



Seq. #:	Machine Or Operation:	Description :
18.0	QC6 	DIMENSIONAL CHECK N/N
19.0	PACKAGING 1 	PACKAGING RESOURCE #1 U 97-04-12
20.0	QC21 	FINAL INSPECTION/W/O RELEASE ① U 97-04-12

Job Completion



U 97-04-12

Date: Thursday, 4/12/2007 1:09:54 PM
 User: Kim Johnston

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Job Number	: 30183			Part Number	: D412664203A	
Estimate Number	: 10804			Drawing Number	: NCR 095	
P.O. Number	:			Project Number	:	
This Issue	: 4/12/2007		S.O. No. :	Drawing Revision	:	
Prsht Rev.	: NC			Material	:	
First Issue	: 1/4/2007		Type :	Due Date	: 1/11/2007	
Previous Run	: 29270			Qty:	1	Um: Each
Written By	:					
Checked & Approved By	:					
Comment	:					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	 <i>Packwork + Label 07.04.2011 CHG 0030</i>
		Comment: PACKAGING RESOURCE #1 REMOVE FROM STOCK D412-664-203 RECORD B/N	
2.0	D412664203A	Crosstube Aft High W/ armour shield	 REFERENCE ONLY
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Crosstube Aft High W/ armour shield	
3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1 REMOVE SUPPORT D2896-1 FROM CROSSTUBES AND LABEL SUPPORT WITH B/N OF CROSSTUBE IT CAME OFF OF	
4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1 REMOVE CENTRE ABRASION STRIP AND CLEAN OFF ALL ADHESIVE RESIDUE	